

Date: Thursday, 22/01/2009 11:00:28 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 45074		
Estimate Number	: 10104		
P.O. Number	:	Part Number	: D2012107
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: D2012-107 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 40274	Material	:
Written By	:	Due Date	: 29/01/2009
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est: D 01.11.08 Re-format, Drawing to Rev. C SM Est Rev: E Now on Waterjet 06-06-13 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.3360 sf(s)
304/316 .063 Sheet
(M304S063)
Batch: 108724 HB9-1-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2012-107
Dwg Rev: E HB9-1-22
Prog Rev: E

2-Deburr if necessary

M-1

09/01/22

40

40x

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5096123

40

contin

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Form on press using DT8242 as per Dwg D2012-107

5096126 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



cocker

Comment: INSPECT WORK TO CURRENT STEP

S 02/01/26 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-1

Identify and Stock

Location: _____

ST8

AS

09/01/26

(40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



mk 09-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

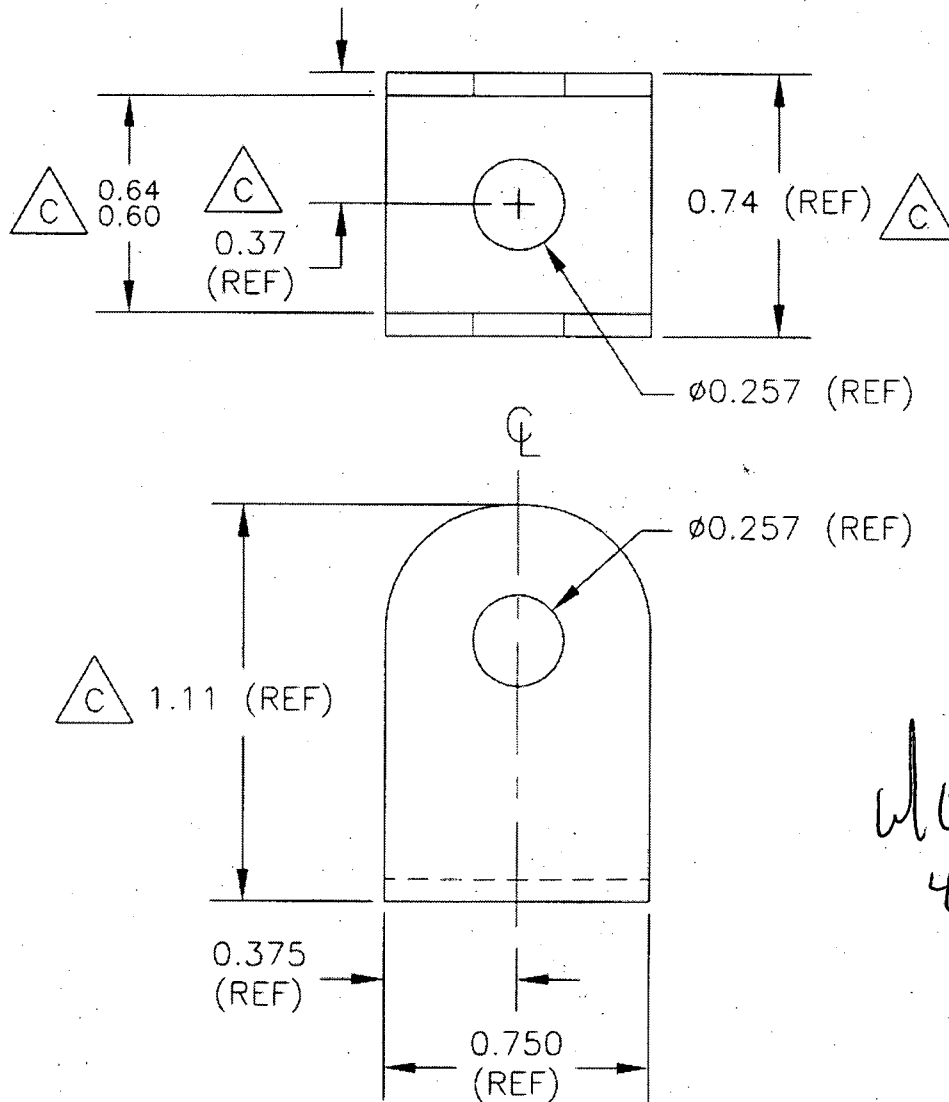
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
CC. 01.04 DS

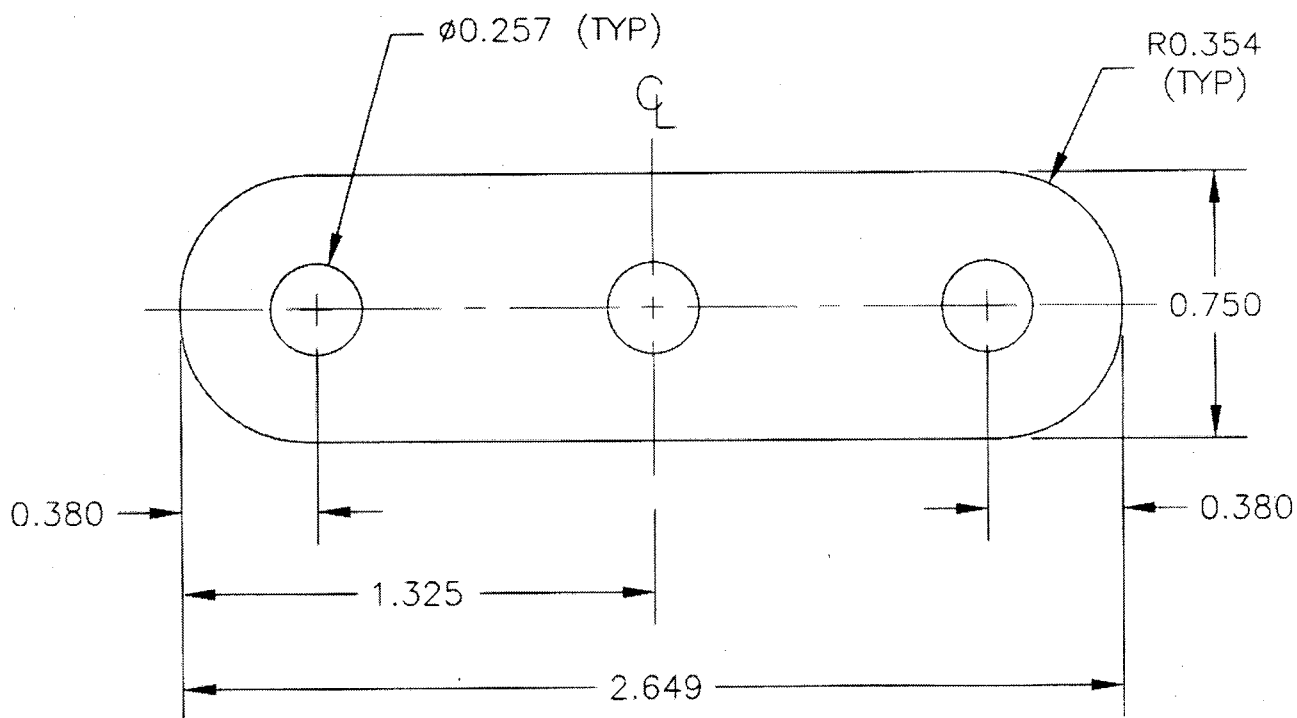


MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00-01-04 DS



D2012-107 FLAT PATTERN

Wb 45074

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES